

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 02/05/2008 7:03:50 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY 25"

Job Number: 38978

Part Number: D3298001

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend tube as per template D3298-001T1 & Dwg D3298

Flare end as per Dwg D3298.

Ensure that sleeves and coupling are installed first

X5

ml08/05/12

5.0 QC5

INSPECT WORK TO CURRENT STEP



5 08/05/12 (S)



Comment: INSPECT WORK TO CURRENT STEP

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

SC 8/05/12 (S)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/14 (S)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08/05/13

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DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3298	REV. A SHEET 1 OF 7
DATE 04.07.06		TITLE TUBE ASSEMBLIES	SCALE NTS

RELEASED
04.07.06 *RF*

A	04.07.06	NEW ISSUE
A1	RF 04.07.06	CORRECT VIEW D3298-003 FOR D3298-001/003 16.00 WAS 16.50
A2	RF 03.03.06	FOR D3298-001/003 16.00 WAS 16.50

P/N	TEMPLATE	CUT LENGTH OF TUBE	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL	<i>W08/26</i>
D3298-001	D3298-001T1	25.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	(WW-T-700/6)
D3298-003	D3298-003T1	27.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	(WW-T-700/6)
D3298-005	D3298-005T1	23.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	(WW-T-700/6)
D3298-007	D3298-007T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	(WW-T-700/6)
D3298-009	D3298-009T1	6.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	(WW-T-700/6)
D3298-011	D3298-011T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	(WW-T-700/6)
D3298-013	D3298-013T1	10.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	(WW-T-700/6)
D3298-015	D3298-015T1	14.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	(WW-T-700/6)

Notes:

- (1) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (2) TUBES TO BE FLARED 37° TO MATE WITH FITTINGS MADE TO MS33514.
- (3) ENSURE SEAMLESS TUBING IS USED.
- (4) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- (6) ALL DIMENSIONS ARE IN INCHES
- (7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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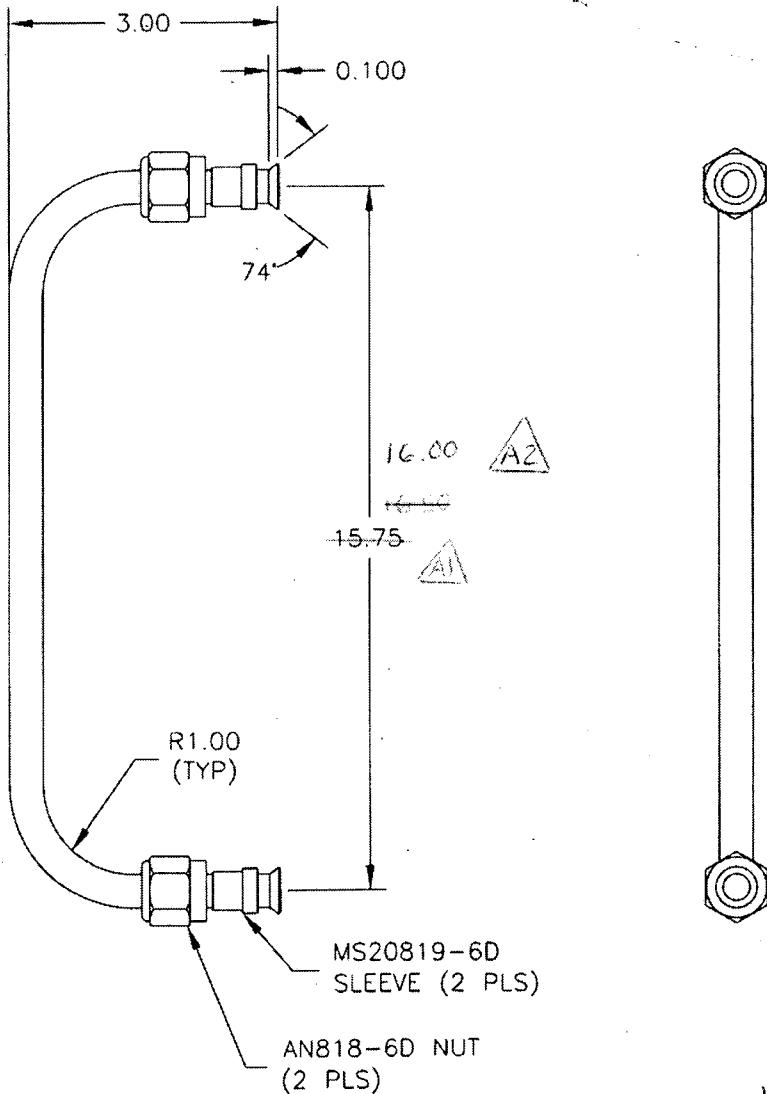
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DATE 04.07.06		TITLE TUBE ASSEMBLIES	SCALE NTS

RELEASED
04.09.09 *HF*

W/O:		WORK ORDER CHANGES					
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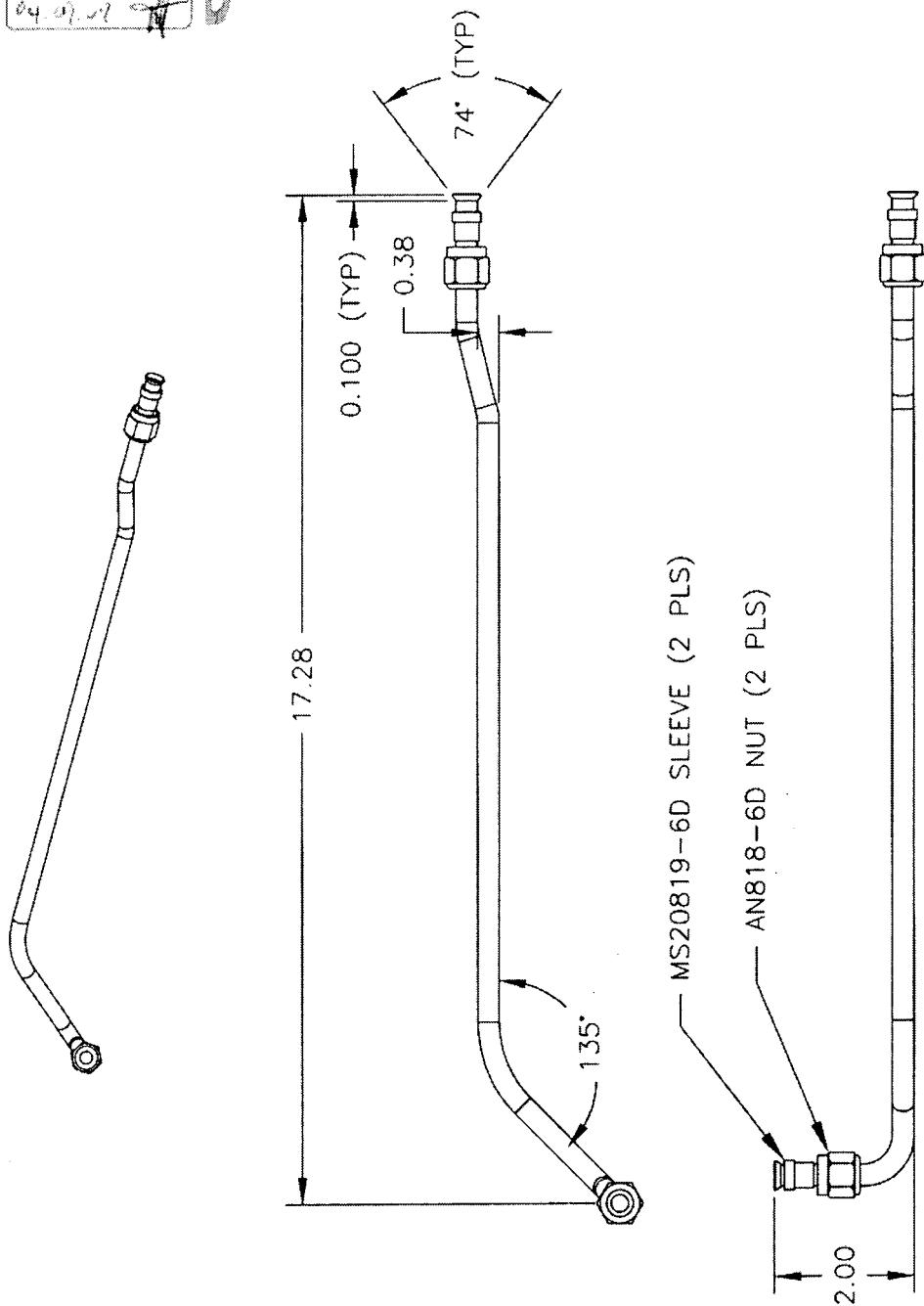
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DATE 04.07.06		REV. A SHEET 3 OF 7 TITLE TUBE ASSEMBLIES SCALE NTS

RELEASED
04.07.07

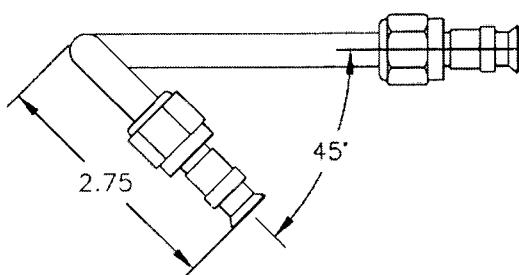


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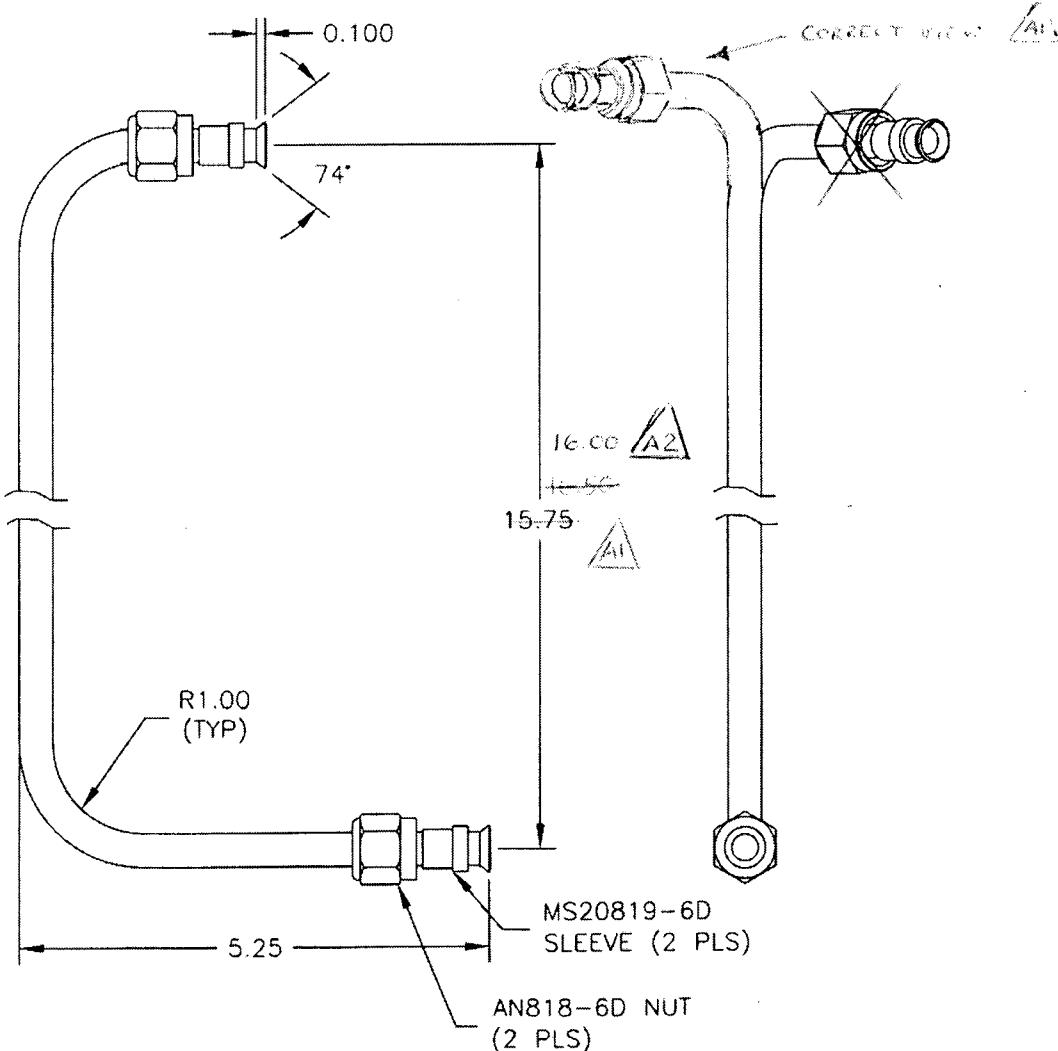
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		D3298	SHEET 4 OF 7
DATE		TITLE	SCALE
04.07.06		TUBE ASSEMBLIES	NTS

D3298-003

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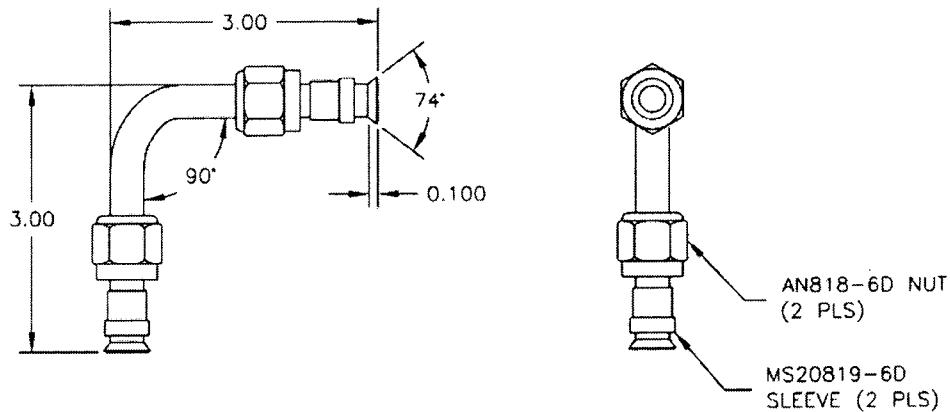
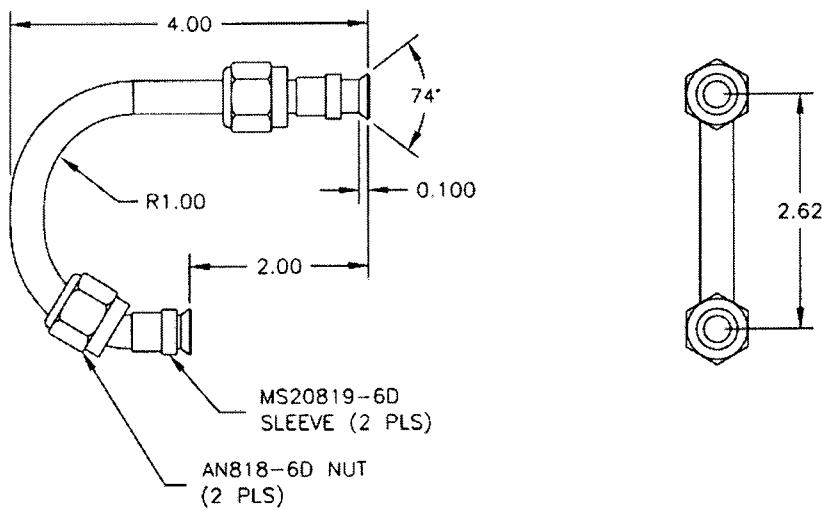


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DRAFT

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DATE		TITLE	SCALE
04.07.06		TUBE ASSEMBLIES	NTS

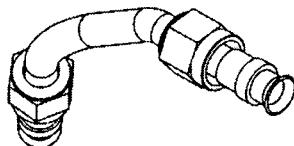
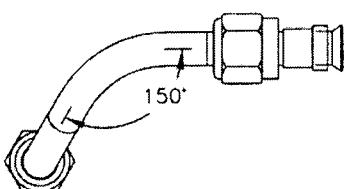
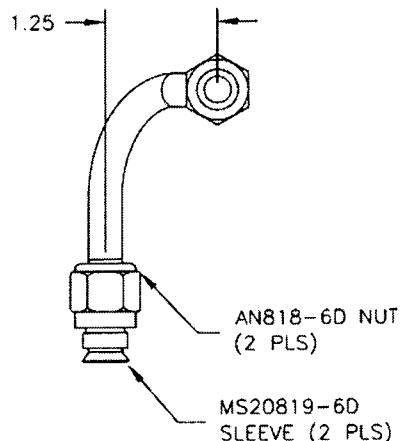
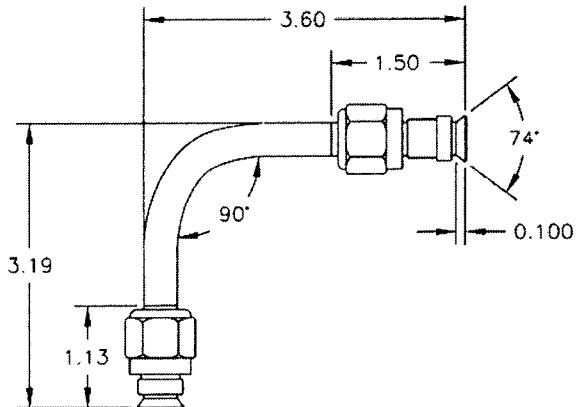
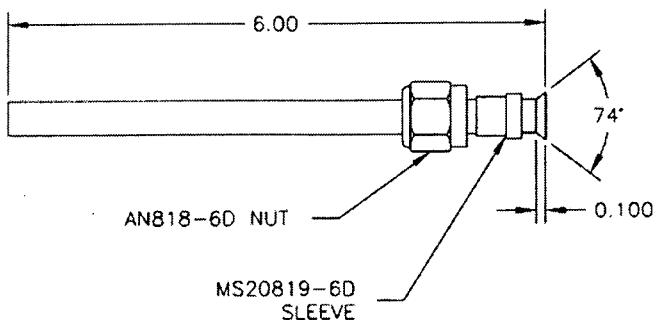
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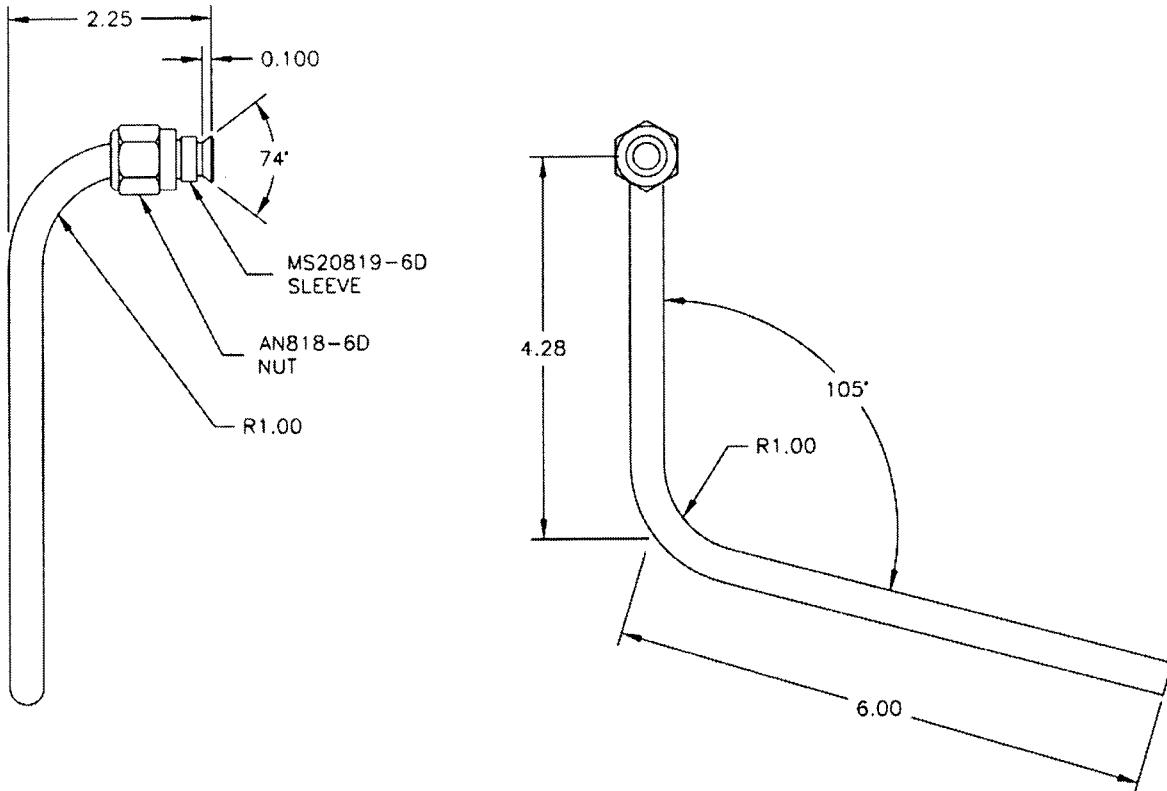
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DATE 04.07.06		TITLE TUBE ASSEMBLIES	SCALE NTS

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04.07.06**D3298-015**

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